

Date: Wednesday, 29/04/2009 3:07:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT
Job Number : 47629	
Estimate Number : 10943	
P.O. Number :	Part Number : K10004
This Issue : 29/04/2009 S.O. No. :	Drawing Number : K10004 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 43788	Material :
Written By :	Due Date : 06/05/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 09.04.29</u>	
Comment : Est : D 05.07.22 Reformat; Added D3428-3 per CHG003 KJ/J LM	
Est Rev:E 08-09-29 revD as per dwg DD verified by:	
Est Rev F 09.02.18 Rev E CHG 005 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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HJ fa JLD 09/05/11



Comment: DOCUMENT CONTROL

Photocopy bluefile for K10004, D205-594-011/-013/-015 & D412-652-011/-21 and type labels per PPP
 K10004 CHG005

5 09/06/24

2.0	D205641011	Ground Handling Wheel
-----	------------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GHW Kit

Qty	Part Number	Description	Batch
2	D205-641-011	GHW Kit	

CHG002

416820 x 1 B43791 x 1 09/05/21 (x2)

3.0	D2570	Bushing
-----	-------	---------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
32	D2570	Bushing	

B43750 x 28 B46431 x 36

09/05/21 (x2)

4.0	D3407041	Tow Ring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tow Ring

batch: *416523*

09/05/21 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE KIT

Job Number: 47629

Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34175

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

B44350

6.0

D34283

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Placard

Pick:

Qty

Part Number

Description

Batch

1

D3428-3

Placard

39675

7.0

D34561

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

B46752

8.0

D5951

Saddle, 205



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Saddle

Pick:

Qty

Part Number

Description

Batch

2

D5951

Saddle

4324612
39793 x 2

9.0

D5953

Saddle, 205



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Saddle

Pick:

Qty

Part Number

Description

Batch

2

D5953

Saddle

"Dev B"

47631

10.0

D5955

Saddle, 205



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Saddle

Pick:

Qty

Part Number

Description

Batch

2

D5955

Saddle

43249

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT

Job Number: 47629

Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D5957

Saddle, 205



9/1/24 (X) 047633 SP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Saddle

Pick:

Qty Part Number Description
2 D5957 Saddle

Batch

39796x3

047633x1

SS 09/05/21 (X2)

12.0

AN451A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty Part Number Description
16 AN4-51A Bolt

Batch

M110320

SS 09/05/20 (X2)

13.0

AN515A

Bolt



Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty Part Number Description
32 AN5-15A Bolt

Batch

M111668 x 15
M110153 x 49

SS 09/05/20 (X2)

14.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number Description
2 AN5-36A Bolt

Batch

M110731

SS 09/05/20 (X2)

15.0

AN542A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty Part Number Description
2 AN5-42A Bolt

Batch

M1108084

SS 09/05/20 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SADDLE KIT

Job Number: 47629

Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN543A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
2 AN5-43A Bolt

M108302

SS 09/05/20 (x2)

17.0

AN545A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
2 AN5-45A Bolt

M107939

SS 09/05/20 (x2)

18.0

AN960JD516

Washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch
80 AN960JD516 Washer

M111279x46

M110523x114

SS 09/05/20 (x2)

19.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
16 MS21042L4 Nut

M110450

SS 09/05/20 (x2)

20.0

MS21042L5

Nut



Comment: Qty.: 40.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
40 MS21042L5 Nut

M109840

SS 09/05/20 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SADDLE KIT

Job Number: 47629

Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS210434

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch:

M111295

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

G

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 09.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
LANDING GEAR INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 412	D412-652-011 D412-652-021
BELL 205/212/214	D205-594-011 D205-594-013 D205-594-015
BELL 204	D205-594-021 D205-594-023

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

PART NUMBER	K10004	D412-652-011 D412-652-021	D205-594-011 D205-594-013 D205-594-015 D205-594-021 D205-594-023
D205-641-011	2	2	2
D2570	32	32	32
D3407-041	2	2	2
D3417-5	4	4	4
D3428-3*	1	N/A	1
D3456-1	2	2	2
D5951	2	2	2
D5953	2	2	2
D5955	2	2	2
D5957	2	2	2
AN4-51A	16	16	16
AN5-15A	32	32	32
AN5-36A	2	2	2
AN5-42A	2	2	2
AN5-43A	2	2	2
AN5-45A	2	2	2
AN960JD516	80	80	80
MS21042-4 (OR L4)	16	16	16
MS21042-5 (OR L5)	40	40	40
MS21043-4	2	2	2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

*REQUIRED WITH D205-594-011/-013 INSTALLATIONS ON 214 AIRCRAFT ONLY

E	D3407-041 WAS D3407-045; REMOVE D3812-1; REASON: TOW RING IS CHANGED ON D205-634-011/ D204- 635-011 SKIDTUBES @ CHG 007 AND D205-634-015 SKIDTUBES @ CHG 006. SEE DSI 9417/9418 @ REV. B	PH	09.01.28
D	D3407-045 WAS D2707-041; D3456-1 WAS AN970-4; MS21043-4 REPLACES MS21042-4 (QTY 2); ADD D3417-5 AND D3812-1; ADD REFERENCE TO D205-594-021/-023	PH	08.09.11
C	ADD D3428-3 PLACARD	PH	05.07.22
B	ADD D2707-041 OPTION	DS	00.11.22
A	NEW ISSUE	DS	00.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		K10004	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SADDLE KIT	NTS
DATE	09.01.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	